

Work Order ID 70910-1

Friday, June 17, 2011 7:42:32 AM



Page 1

Item ID: D3023-1

Accept



Setup Start



Revision ID:

Item Name: Back Panel

Stop



Start Date: 6/16/2011 Start Qty: 1.00



Required Date: 6/23/2011 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3023

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3023

Dwg Rev: A

Prog Rev: A

***graind direction along 28.100" ***

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

ERIC L.

B11-7-11

(2)

B11-7-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

8 11/17/11

(2)

Quality Control

130

NC BRAKE

0.00



Brake NC

Memo

0.00

1-Bend as per Dwg D3023 2-form edge of back pan as per dwg D3023 using
D3017-041 back frame

SP 11/17/11

(2)

Brake NC

11-11-17

(X1)

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8 11/17/11

Quality Control

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Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

IX φ m- 11/11/17

160

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

IX φ m- 11/11/17

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1. BR 11-11-17.

m 118489

2:30
3200F

3:00

W/O:		WORK ORDER CHANGES					
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Item Name: Back Panel

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Required Date: 6/23/2011 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180



Packaging

Identify as per dwg & Stock Location: *6-A*

0.00

Memo

w/o
70586

0.00

Packaging

EP 11/11/18 2

190



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

11/11/21

11-11-21
(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

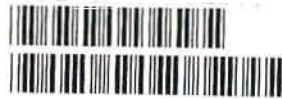
Friday, June 17, 2011 7:42:39 AM

Page 1

Work Order ID: 70910

Parent Item: D3023-I

Parent Item Name: Back Panel



Start Date: 6/16/2011

Required Date: 6/23/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP C 02.01.23 Revised NG
IPP Rev:D 08-04-16 now water jet DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased	No			100	sf	24,4000	2.8777	3,029158	0.5		
2024-T3 .032 sheet													

Location

Loc Qty

Loc Code

MAT22

24.4

111699

0.5

113189

23.9

118243

118243

2

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	70911
Description: Back Panel		Part Number:	D3023-1
Inspection Dwg: D3023	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	.131	>		V Bo2	
Ø0.191	+0.005/-0.001	.193	>		V	
1.660	+/-0.010	1.660	>		V	
0.375	+/-0.010	.374	>		V	
1.340	+/-0.010	1.341	>		V	
2.375	+/-0.010	2.373	<		V	
0.375	+/-0.010	.373	<		V	
25.28	+/-0.030	25.25	<		T Bo2	
27.03	+/-0.030	27.03	=		T	
28.10	+/-0.030	28.10	=		T	
1.30	+/-0.030	1.298	<		V	
2.375	+/-0.010	2.374	<		V	
8.711	+/-0.010	8.711	=		T	
5.597	+/-0.010	5.597	=		V	
8.57	+/-0.030	8.57	=		T	
1.970	+/-0.010	1.967	<		V	
7.42	+/-0.030	7.42	=		V	
10.92	+/-0.030	10.92	=		T	
14.75	+/-0.030	14.75	=		T	

Measured by:	RB
Date:	11-7-11

Audited by:	J
Date:	11/14/14

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.11.27	New Issue	KJ/EC	JA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

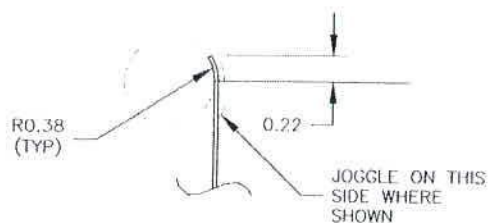
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

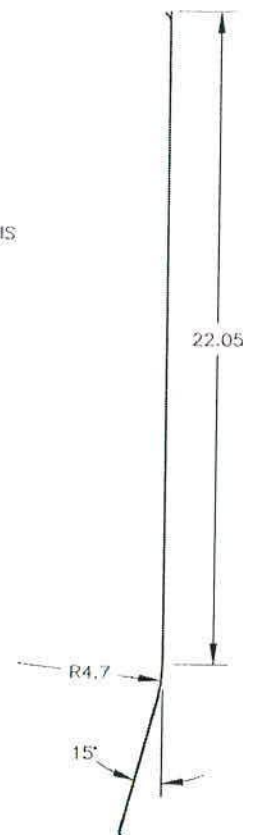
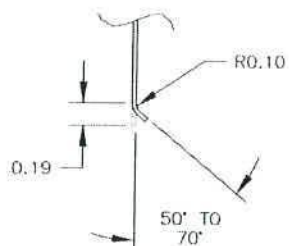
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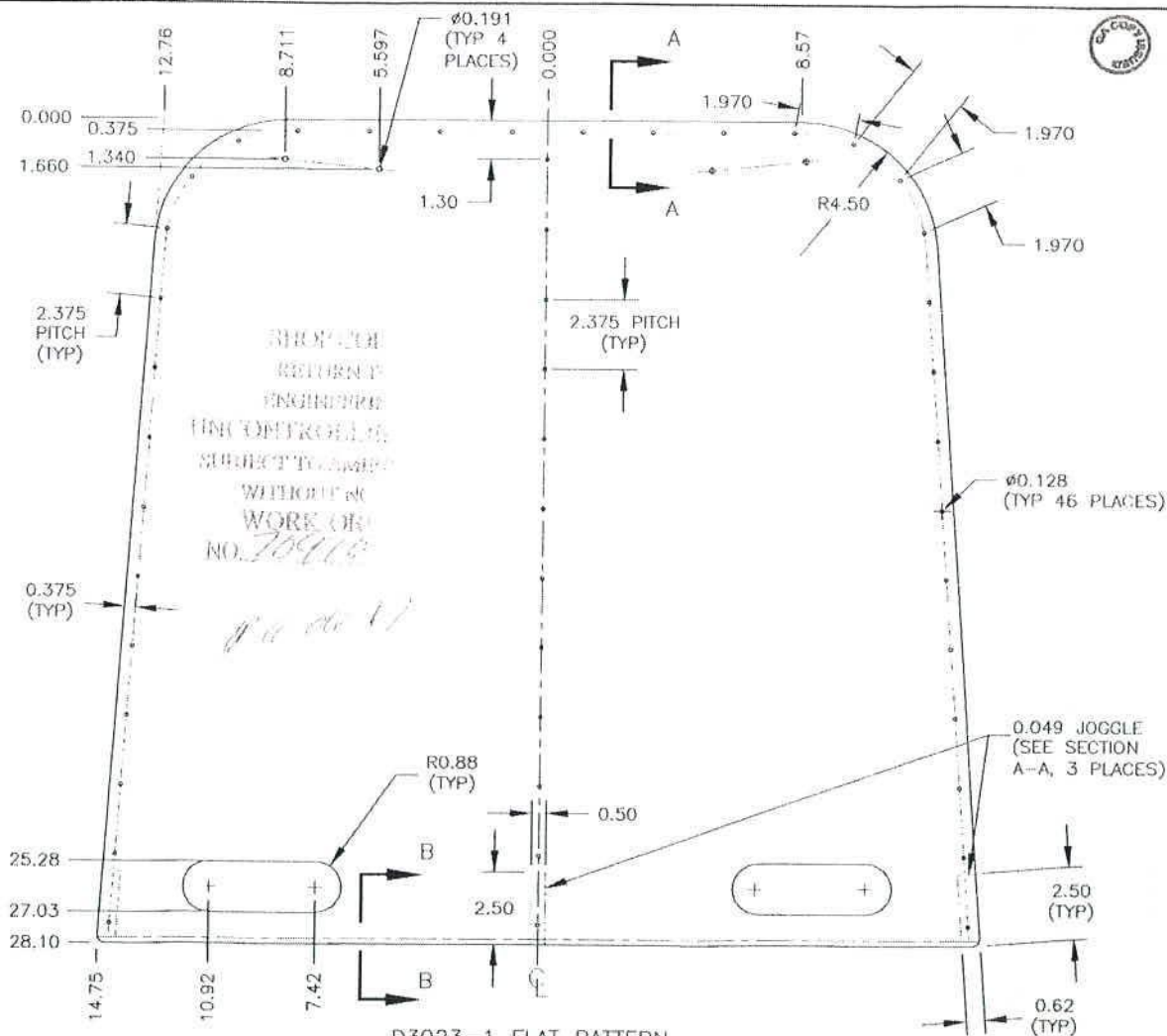
SECTION A-A
SCALE 1:1
(TYPICAL, EXCEPT WHERE SHOWN)



SECTION B-B
SCALE 1:1
(BOTTOM EDGE ONLY)



D3023-1 BEND DETAIL



D3023-1 FLAT PATTERN

D3023-1 BACK PANEL:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES.
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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A	01.05.18	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3023
DATE		TITLE BACK PANEL
01.05.18		REV. A SHEET 1 OF 1 SCALE 1:4

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